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D117-762-011
Job Sheet 166639



Part No: D117-762-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 11/7/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Airwork (NZ) 1984 Ltd (CAIRW01)

PO Box 72516, Auckland Papakura, , 2244 New Zealand ph:+ 64 9 295 2100 fx:+ 64 9 295 2102.

Note: DWG DSI9771 REV A, IIN-D117-762 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA DD verified by:ec IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP REV:E 15.06.11 IIN REV.D DD VERF:JLM IPP REV:F 17.01.17 PER CHG004 (dsi9771) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/6/17	0.00	0.00	Start up container	SMB
100	DC	1 pcs	11/7/17	0.00	1.52	DC	17-11-324
110	Packaging	1 pcs	11/7/17	0.00	0.00	Packaging1	SMB
120	QC	1 pcs	11/7/17	0.00	0.00	QC4	SMB
130	Packaging	1 pcs	11/7/17	0.00	0.00	Packaging3	DAS 28 9-89
140	QC21-FG	1 Ea	11/7/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile & type labels per PPP D117-762-011 CHG003

Descriptions: 130 - Identify and pack for shipping as per PPP D117-762-011 Location :FG081

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Packaging	AN6C52A FM137190	2	17	0	0
	D117-762-044 1000 Blue	1	0	0	0
	D3512-041 5005275	2	12	0	0
	D5300-1 163432X1	2	15	0	0
	D5301-1 F 162332	2	5	0	0
	MS21043-6 5005257	2	50	0	0

Part Specifications

Specifications could not be found.

Plex 10/12/17 3:08 PM dart.Michaud-Febrille.Victoria

5002865.

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

QA Closed: _____ Date: _____

DQA: _____ Date: _____

Work Order: Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermforming ☐ Large Fab ☐ Composite ☐ Small Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other	
Date: _____		Station # _____		QTY Effective: _____		MRB (QS1042) Approval	
Completed By		Lead hand / Supervisor		Approval Verification		QC / QA Coordinator	
Change No:		Operation:		Revision:		PART NO:	
1		Start up Operation		D117-762-011		D117-762-011	
Job No: 166639		Mfg Date: 11/03/17		Skidtube with Standard Wearplates Fits LH or RH			
Description		S005798					
Root Cause		DART AEROSPACE					
Environment		Design					
Design		Doc/Data					
Equip/Tooling		Handling/Pre					
Material		Internal Transport					
Tribal Knowledge		LOA					
Substation		Past Expiry Date					
Misidentified		Past Due					
Use for Testing		Crimp/Kink/Kippie/Wave		Contamination		Positioned Wrong	
Poor Information		Crushing		Cut Too Short		Outside Dimensions	
Rushing		Heat Treat		CounterSink		Over/Under tolerance	
Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Part Lost/Missing	
Process Improvement		Marks/Chatter		Drill Holes		Part Moved	
Manufacturing Process		Misaligned/off center		Fit/Function		Drawing	
OTHER:		Mislabeled		Off-set		Finish	
		Out of Sequence		Misread		Turning Sequence	
		ig Stock Pulled		Program			
		r Loss/Surge					

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 3

REF FAA STC: SR01853SE

REF: TC LETTER OF ACCEPTANCE RDIMS-4374899

REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D145-762-XXX Skid tubes with a structurally superior lug design. This service instruction only affects D145-762-043/-013/-113 Skid tubes at change 004 or earlier and D145-762-045/-015/-115 Skid tubes at change 001. It is highly recommended to install DSI 9731-011 GHU Upgrade Kit in order to prevent early structural failure of the D145-762-XXX Skid tubes. Each DSI 9731-011 GHU Upgrade Kit provides the necessary parts and hardware for installation on one skid tube.

2.0 INSTALLATION

- 2.1 Remove (qty 4) D3864-1 Bushings per Skid tube by removing (qty 2) AN6C51A Bolts and (qty 2) MS21043-6 Nuts
- 2.2 Loosely install (qty 2) D5300-1 GHU Bushing & (qty 2) D5301-1 GHU Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.3 Install AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.4 Torque AN6C52A Bolts 160 - 190 In-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9731-011	GHU UPGRADE KIT
2	D5300-1	GHU BUSHING
2	D5301-1	GHU PLUG
2	AN6C52A	BOLT
2	MS21043-6	NUT

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

A	NEW ISSUE	AP	15.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9731	SHEET 1 OF 2
APPROVED	CH	TITLE	SCALE
DE APPR.	TH	GHU UPGRADE KIT	NTS
DATE	15.11.02	COPYRIGHT ©2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

5.0 PARTS LIST

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN960C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE